

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-024966**Date Inspected:** 30-May-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Lei/Wen/Shigang/Feng /Wen**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Bike Path**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Scott Leavitt, was present during the times noted above for observations relative to the work being performed.

Bay 1

This QA Inspector noted that there are 14 Bike Path Handrail components identified as BKR-NS-3 that are in various stages of final pick-up and will be ready for final VT soon.

This QA Inspector noted that there are 32 Bike Path Handrail components identified as intermediate BKR-NS-2 that are in various stages of final pick-up and will be ready for final VT soon.

This QA Inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

Bay 5

The following Traveler Rail components are in this bay waiting further processing: 3022TR1-001, 3020TR1-001, 3010TR1-002, 3025TR1-001, 3025TR1-002, 3025TR1-003, 3023TR1-002, 3023TR1-003, 3009TR1-001, 3023TR1-001, 3026TR1-001, and 3007TR2-001.

The following Bike Path components are in this bay waiting further processing: 26BK2-001, 26BK1-001, 29BK1-001, 29BK2-001, 29BK3-001, 30BK1-001, & 27BK1-001.

Bay 7

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The following Cantilever Box Bracket Assembly component is in this bay waiting further processing:
BKSA21A-001.

Bay 9

The following Traveler Rail components are in this bay waiting further processing: 3003TR2-001, 3009TR2-001, 3016TR1-002, 3016TR1-001, 3016TR1-002, 3014TR2-002, 3013TR1-002, 3013TR2-001, 3016TR4-001, 3016TR3-001, 3016TR2-001, 3014TR2-001, 3014TR1-001, 3014TR1-002, 3016TR4-002, 3013TR1-001 and 3013TR2-002.

This QA Inspector observed 3 Bike Path Handrail components in various stages of fabrication waiting further processing.

This QA Inspector observed the following traveler rail components identified as GGL-MQ-1770-X4025A~C.

The following components are in various stages of fabrication waiting further processing and inspection: SA8006-001-001, 009, 017, 025, 033, 041 and SB8514-001-001, 009, 017, 025, 033, 041.

The following components are in various stages of fabrication waiting further processing and inspection: ZPO6-787-2310-001~050.

Bay 10

The following Bike Paths are in various stages of fabrication waiting further processing and inspection:
BK009A-001 AND BK010A-001

Bay 11

In Process Inspection FCAW

This QA Inspector observed the following work in progress: FCAW welding of weld joint 061 located on BK012A4-001. Welder is identified as 205649. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

This QA Inspector observed the following work in progress: FCAW welding of weld joint 018 located on BK012A3-001. Welder is identified as 053316. ZPMC Quality Control (QC) is identified as Xu Le Feng. The welding variables recorded by QC appeared to comply with the Applicable WPS.

Visual Inspection

The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09305.

This QA inspector performed VT of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel.

The members are identified as:
BK012A2-001-016, 018 A-Side

Magnetic Particle Inspection (MT)

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The following Non Destructive Testing (NDT) inspection carried out as per the ZPMC submitted Notification No 09305.

This QA inspector performed MT of approximately 15% of an area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date.

The members are identified as:

BK012A2-001-016, 018 A-Side

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang at 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Leavitt, Scott	Quality Assurance Inspector
Reviewed By:	Clifford, William	QA Reviewer
